

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018490**Date Inspected:** 27-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007519

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13CW. The weld designations reviewed are as follows:

1. SEG3014M-059, 060, 061, 062, 063, 064

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint is identified as BK004A2-006-002 and 021 located on OBG Bike Path. ZPMC Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint is identified as BK004A2-006-008 and 013 located on OBG Bike Path. ZPMC Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding

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variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint is identified as BK4BSD1-014-006 and 018 located on OBG Bike Path. ZPMC Welder is identified as 208641. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2234-Tc-U4b-F.

FCAW welding of weld joint is identified as BK4BSD1-001-006 and 018 located on OBG Bike Path. ZPMC Welder is identified as 062783. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2234-Tc-U4b-F.

FCAW welding of weld joint is identified as BK4BSD1-014-026 and 007 located on OBG Bike Path. ZPMC Welder is identified as 208641. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-Tc-U4b-F.

FCAW welding of weld joint is identified as BK4BSD1-001-007 and 026 located on OBG Bike Path. ZPMC Welder is identified as 062783. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-Tc-U4b-F.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on OBG Suspender Bracket SB100W, SB102E and SB096W.

This QA inspector observed ABF personnel performed Ultrasonic Testing on OBG Suspender Bracket SB102E and 098W.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint W5-SB1-089-051 ~057 located on OBG steel barrier. Welder is identified as 069712. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2132.

FCAW welding of weld joint W5-SB1-089-063 ~074 located on OBG steel barrier. Welder is identified as 069712. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2133.

FCAW welding of weld joint W5-SB1-080-126 ~131 located on OBG steel barrier. Welder is identified as 201879. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2132.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on OBS steel barrier W5-SB1-048 and W5-SB1-053.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

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contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
